

1005449-44304

FIG. 1

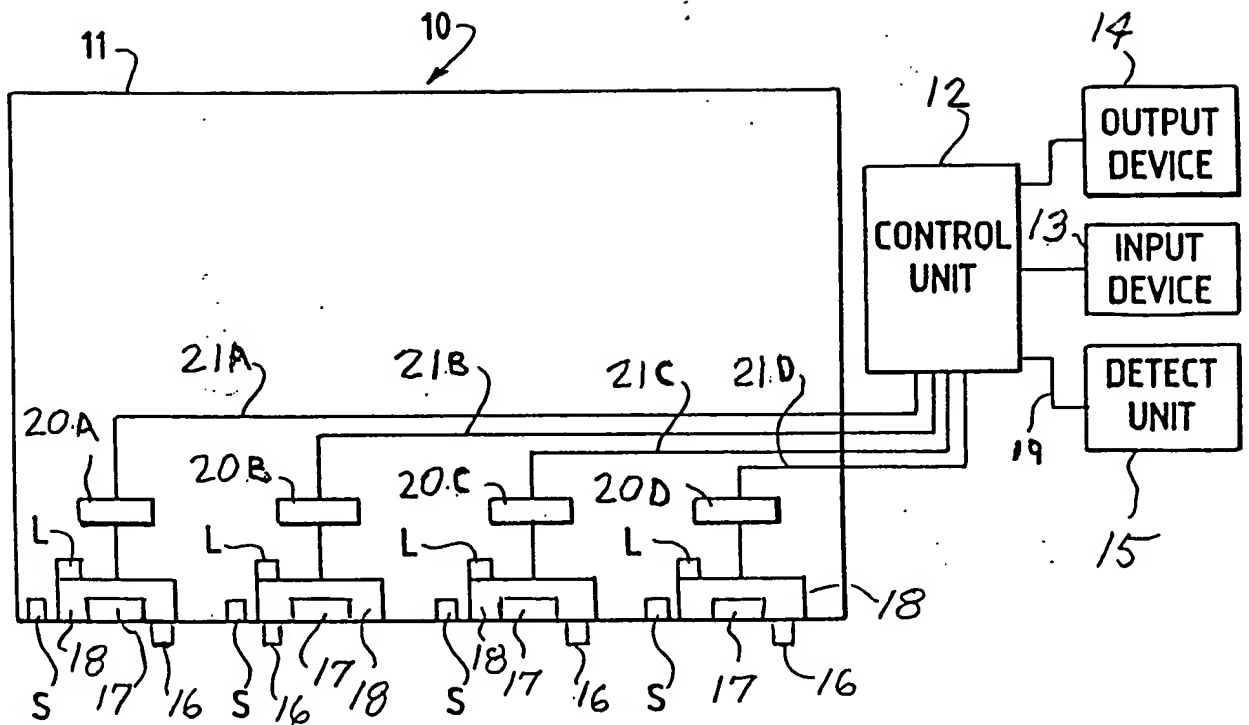


FIG. 2A

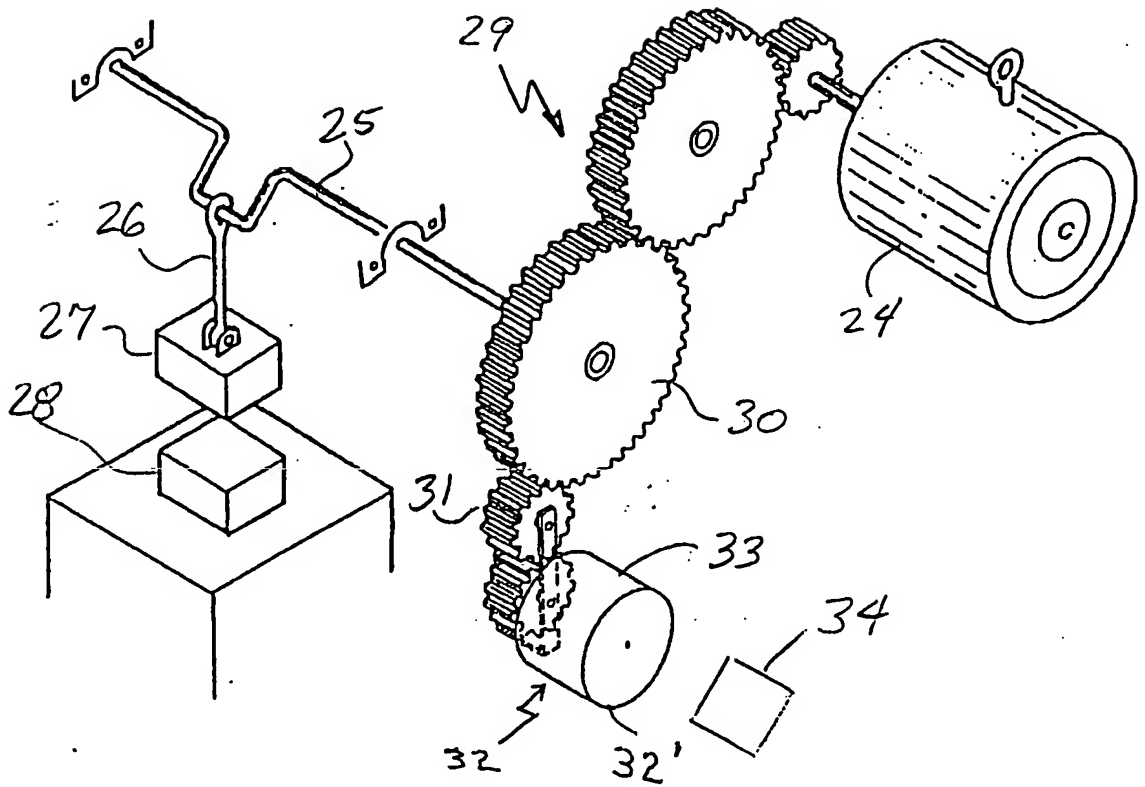


FIG. 2B

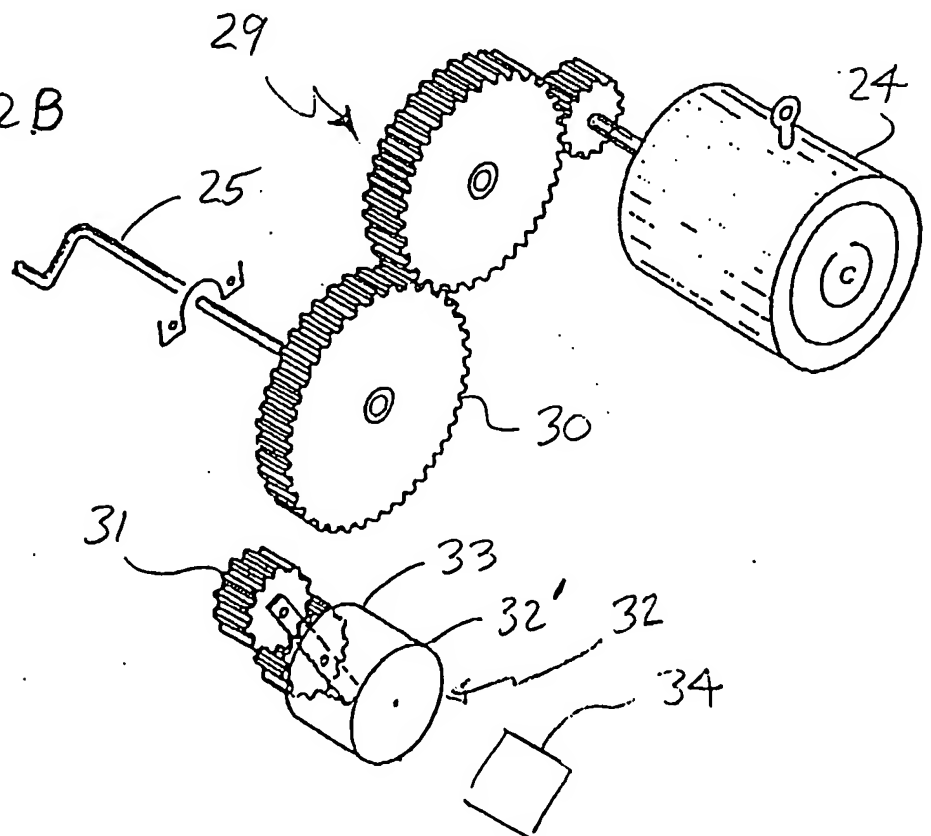


FIG. 2A

FIG. 3

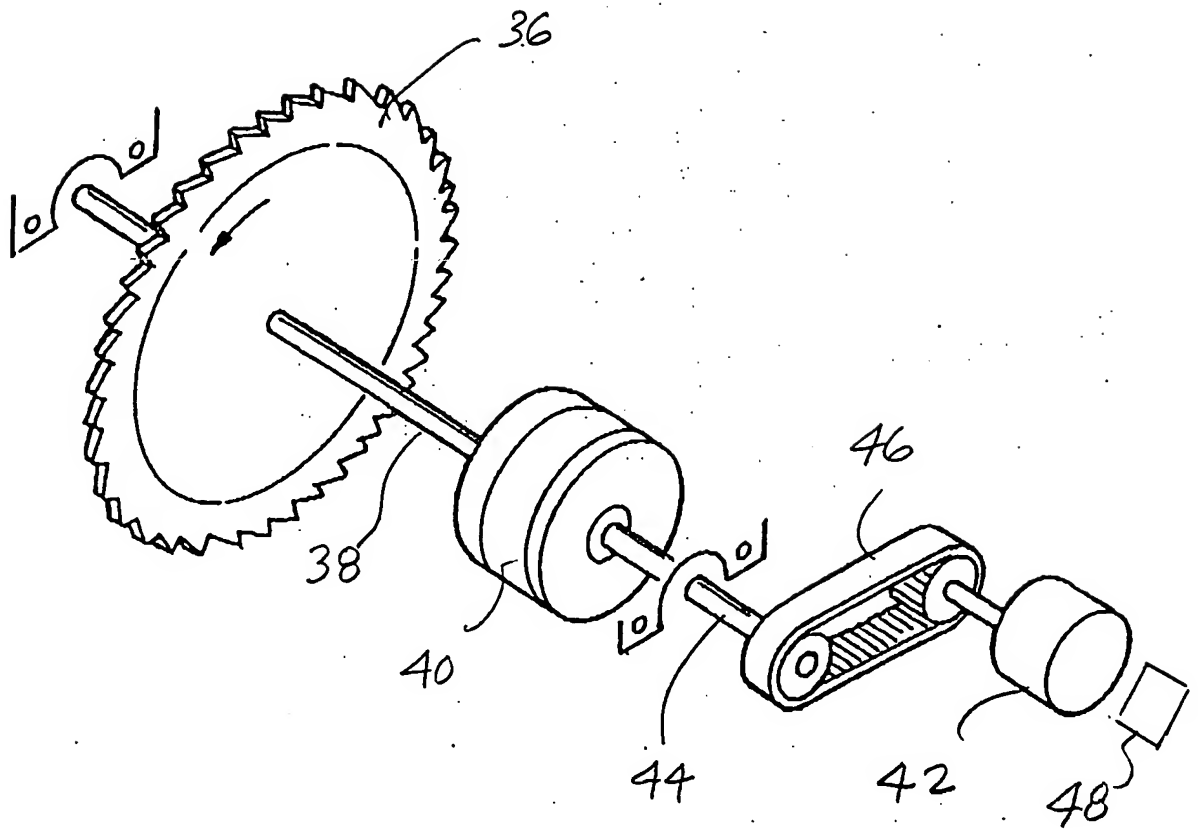


FIG. 4 ZERO SPEED INDICATOR TEST SUBROUTINE  
IN SITU TESTING WHILE THE MACHINE IS RUNNING

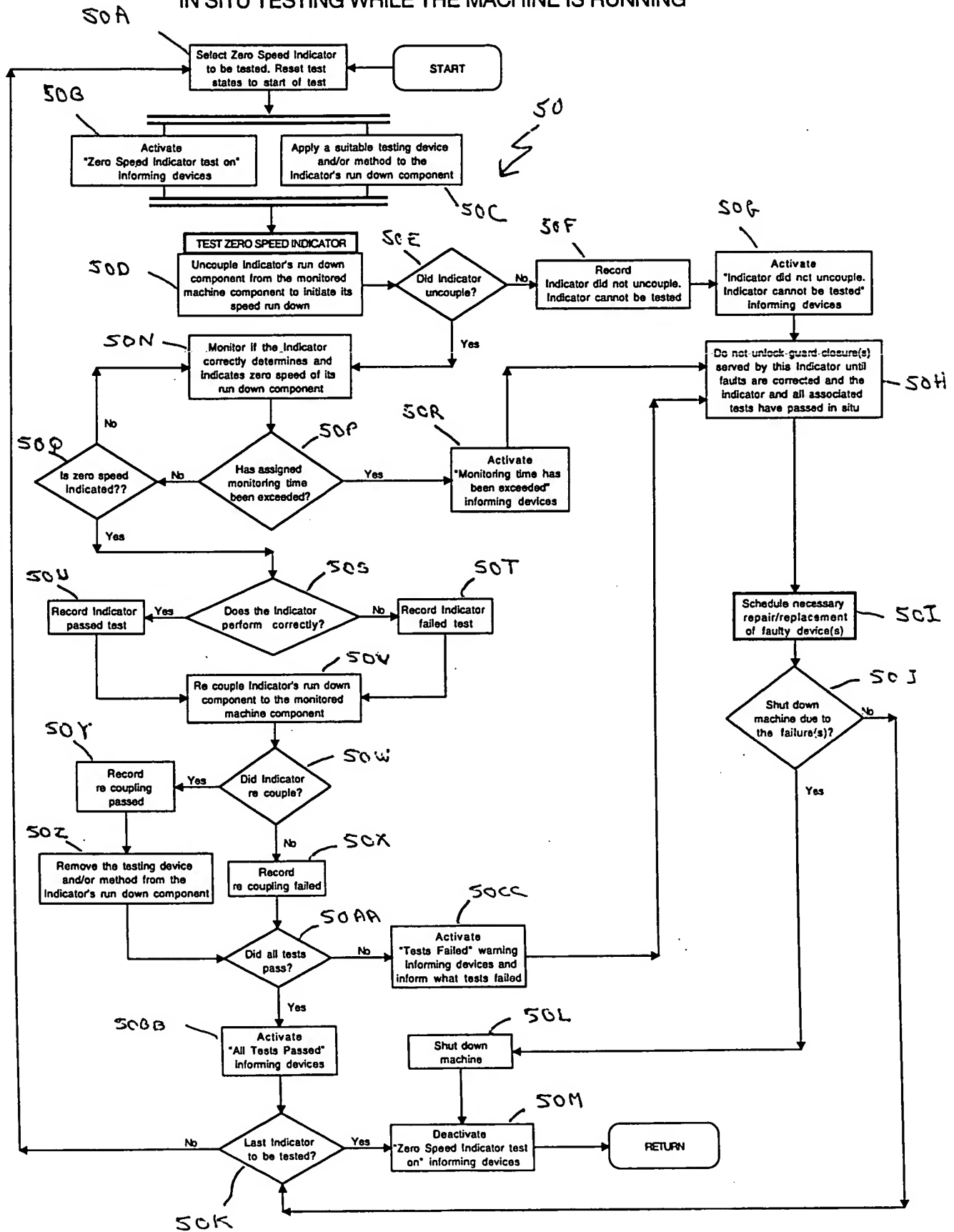
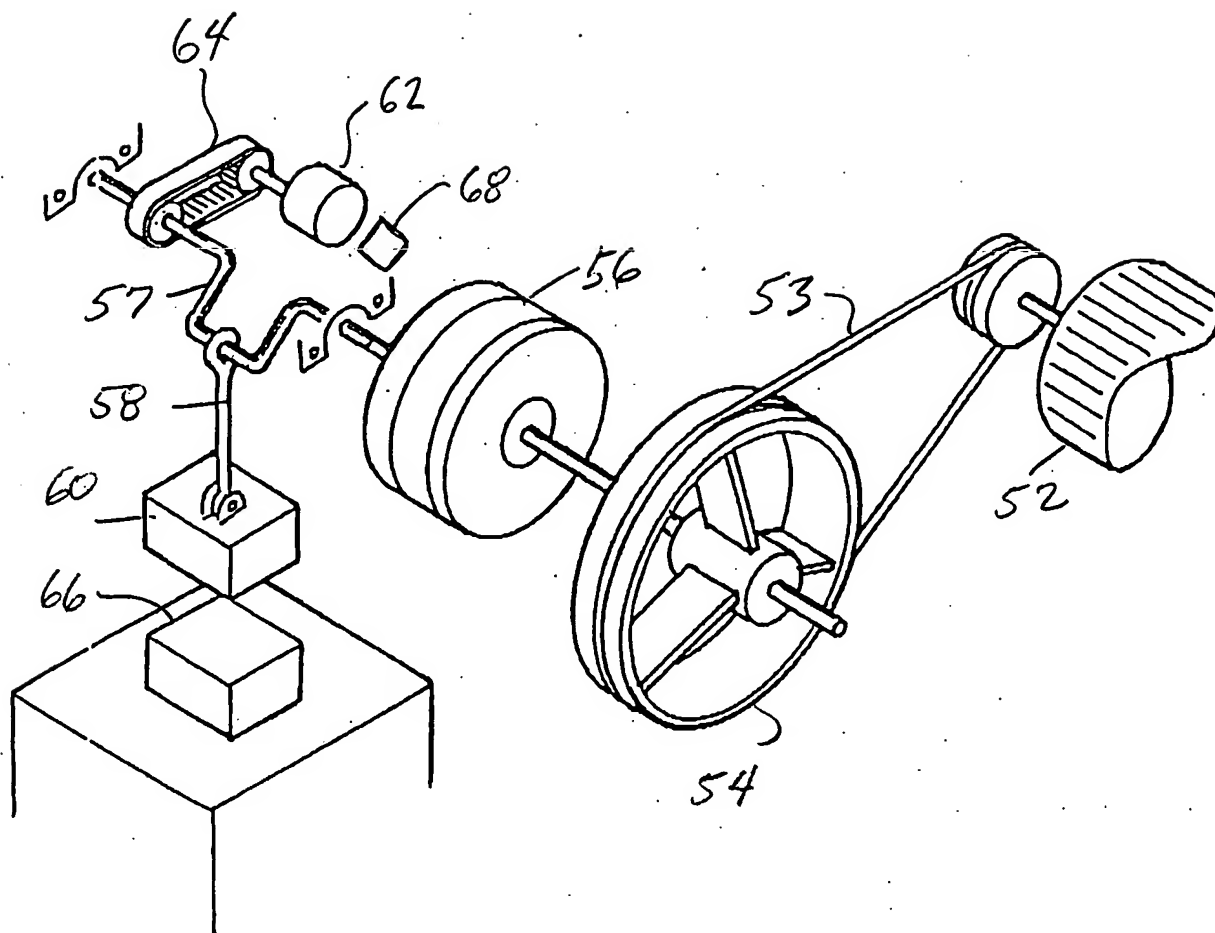


FIG. 5



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**FIG. 6 ZERO SPEED INDICATOR TEST SUBROUTINE  
IN SITU TESTING DURING THE SPEED RUN DOWN PHASES  
CAUSED BY MACHINE STOP INITIATIONS**

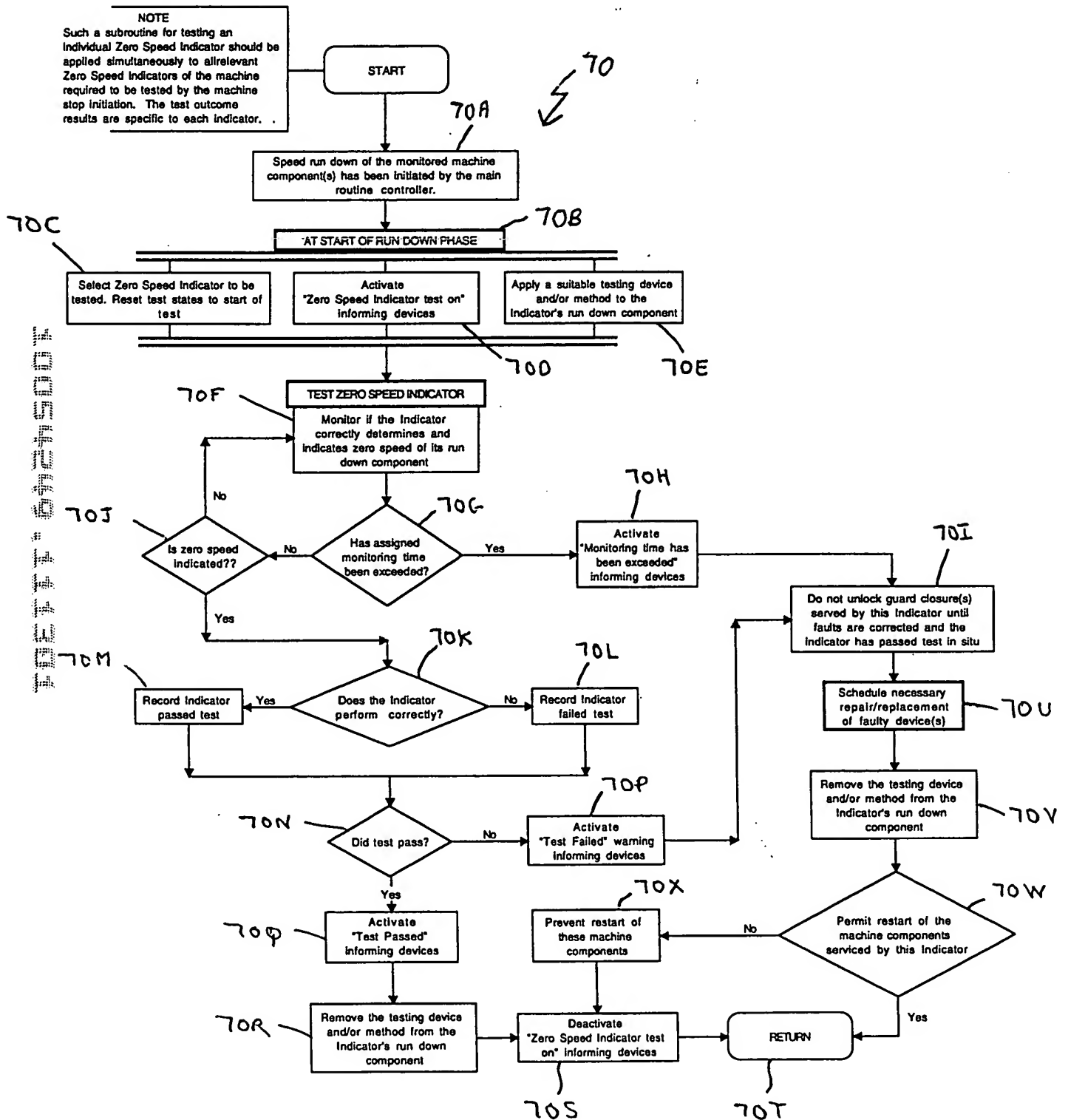


FIG. 7

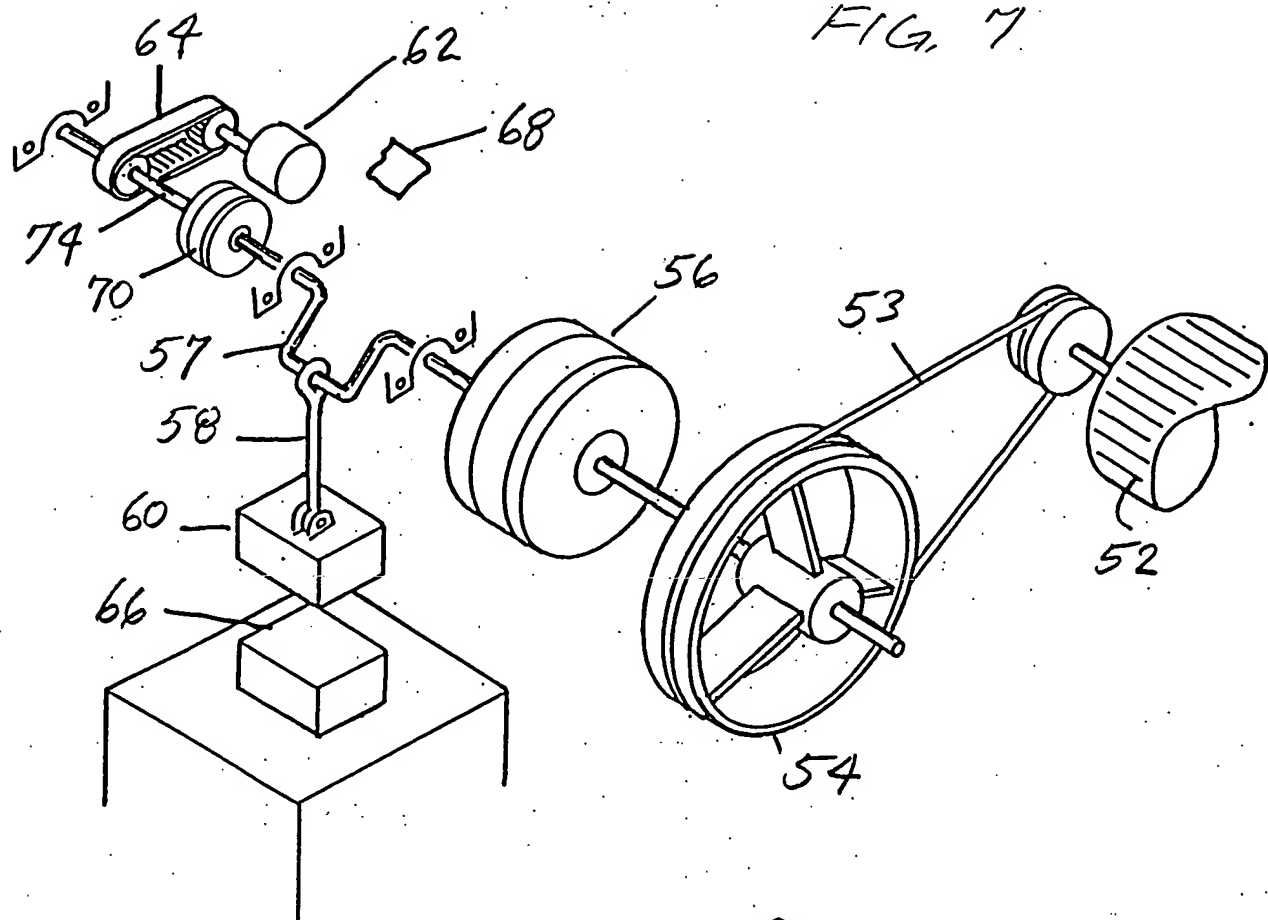
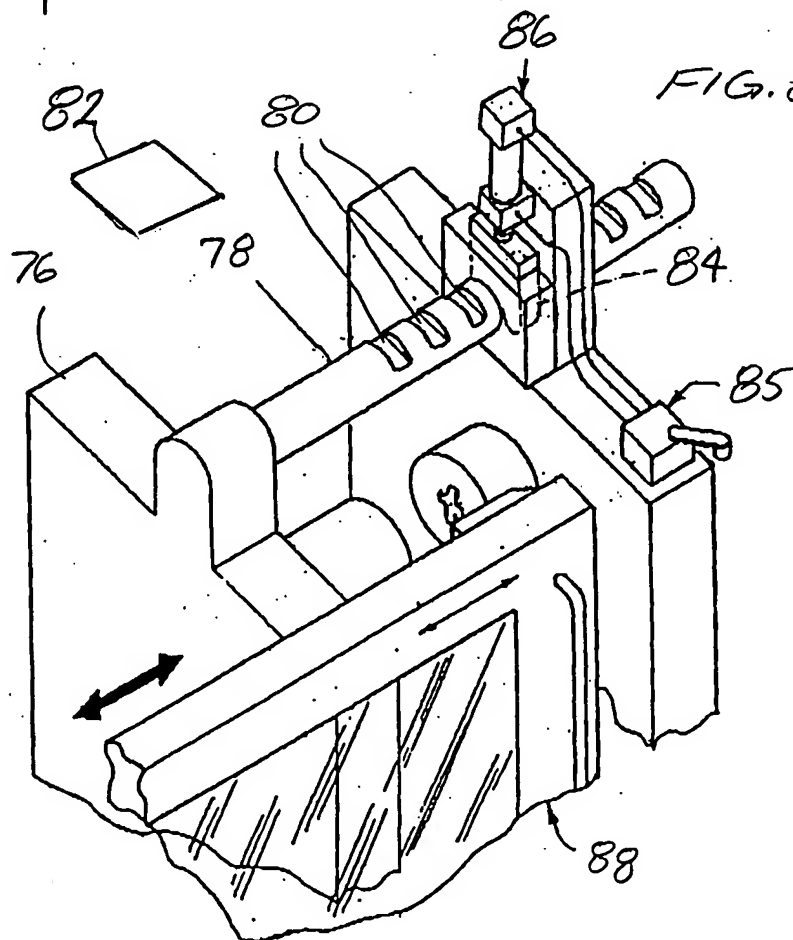


FIG. 8



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FIG. 9 SUBROUTINE FOR INSERTION OF A MOTION INTERFERENCE DEVICE AT SPEED RUN DOWN COMPLETION CAUSED BY MACHINE STOP INITIATIONS

NOTE

Such single location subroutines are to be applied individually but simultaneously to all relevant machine locations where the insertion of a motion blocking interference device is called for by the machine stop. The insertion outcome results are specific to each location.

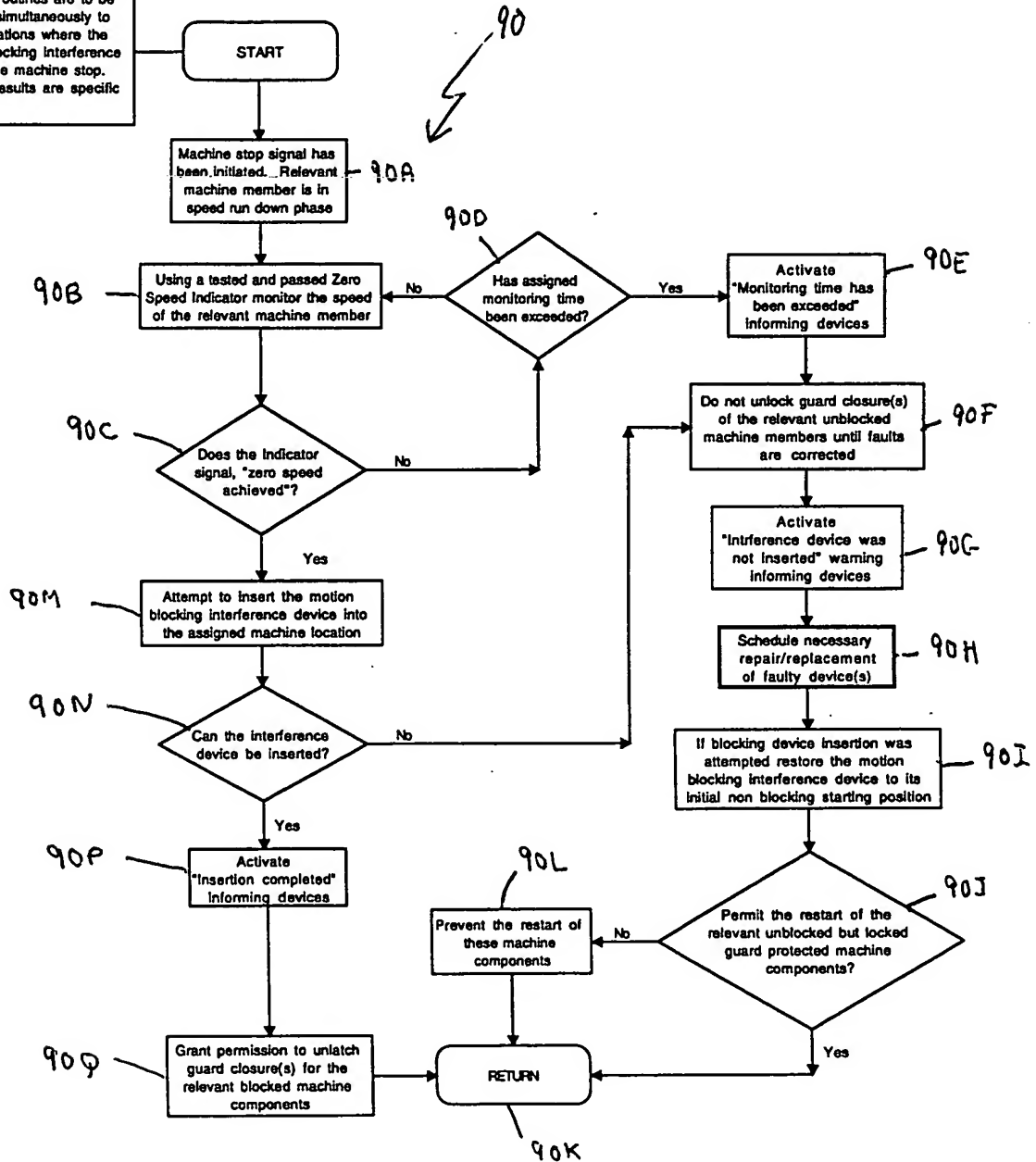
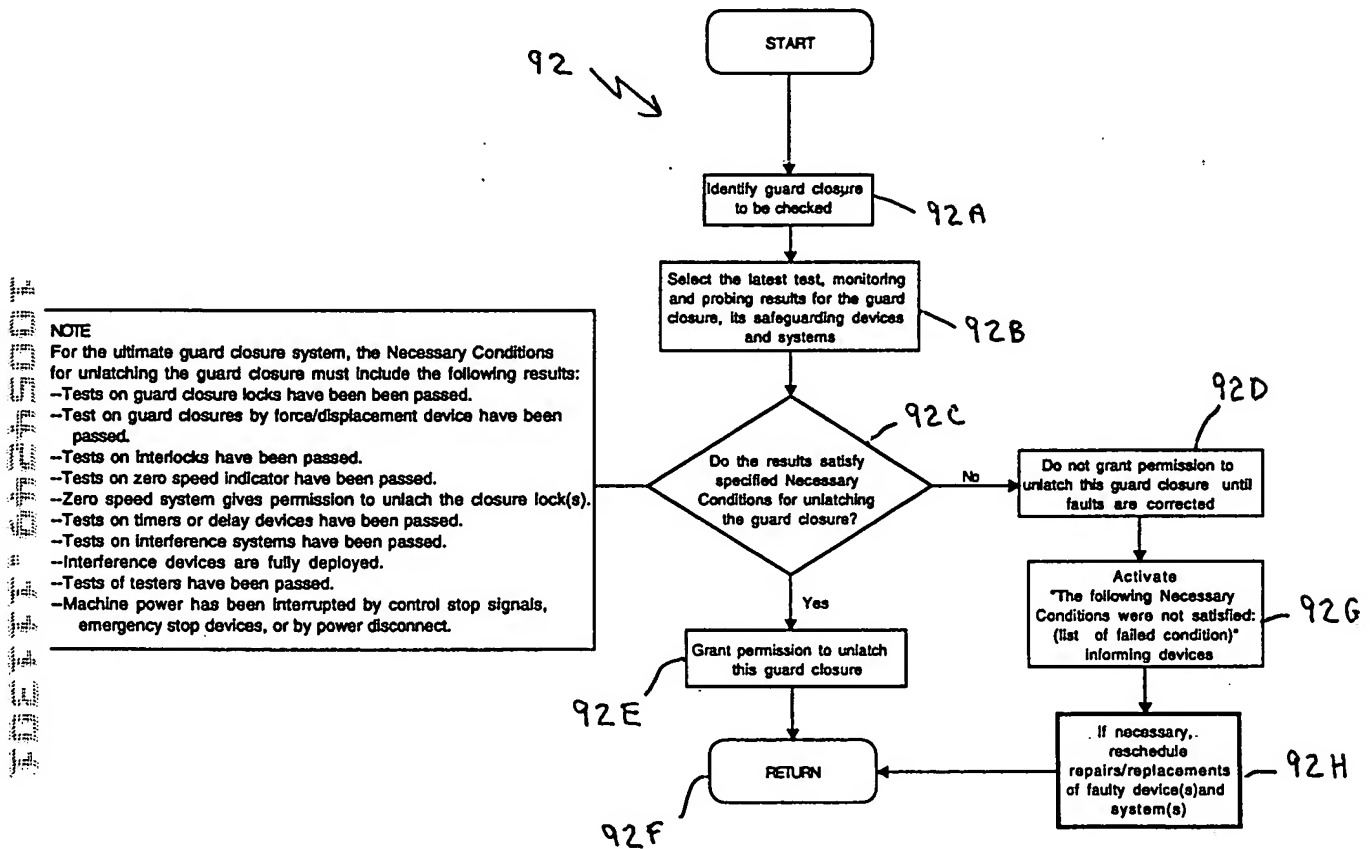




FIG. 12 SUBROUTINE FOR CHECKING THE FULFILLMENT OF NECESSARY CONDITIONS FOR UNLATCHING A GUARD CLOSURE



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